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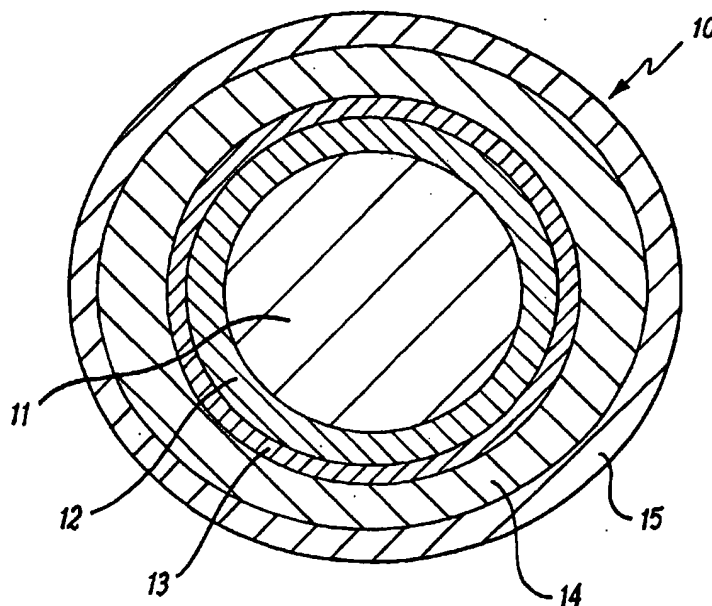
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[Continued on next page]

(54) Title: LIQUID-FILLED CONFECTIONERY COMPOSITIONS



(57) Abstract: A liquid-filled confectionery composition (10), comprising a liquid-containing core (11, 12), an outer layer of confectionery coating (14, 15), and an intermediate protective layer (13) between the core (11, 12) and outer layer (14, 15). The liquid-containing core consists of a liquid (11) contained within a water soluble or biodegradable matrix (12). The edible water impermeable intermediate layer (13) is applied in alcohol and prevents the movement of water between the core (11, 12) and the outer layer (14, 15), thereby preventing the core (11, 12) from drying out.

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**LIQUID-FILLED CONFECTIONERY COMPOSITIONS**

The present invention relates to liquid-filled confectionery compositions and methods of making the same. More particularly, but not exclusively, the present invention, in one embodiment, relates to liquid-filled chewing gum compositions and  
5 methods of manufacturing the same.

Liquid-filled chewing gum and other confectionery compositions are known in the art and typically comprise a liquid core material encapsulated within a solid coating of gum or other confectionery.

A common problem with such compositions arises as a result of the tendency for  
10 moisture present in the liquid centre and/or the atmosphere to ingress into the solid gum or other confectionery coating over time. This ingress of moisture can be detrimental to the integrity of the composition for a number of reasons. Firstly, the moisture content of the liquid centre will reduce over time as moisture gradually migrates into the surrounding coating and this will in turn cause the liquid fill present in the composition  
15 to become gradually less hydrated and more concentrated over time. Secondly, the coating itself will soften as its moisture content increases, which can be detrimental to the appearance and properties (taste, texture etc.) of the coating.

Various attempts to limit the migration of moisture from the liquid core into the solid coating of conventional liquid-filled gum compositions by modifying the  
20 composition and properties of the encapsulated liquid are described in United States Patent Numbers 3,894,154 (Graff *et al.*), 4,156,740 (Glass *et al.*), 4,157,402 (Ogawa *et al.*) and 4,466,983 (Cifrese *et al.*). However, although modifying the composition of the encapsulated liquid can reduce the amount of moisture migration occurring between the liquid core and the coating, a liquid-filled chewing gum/confectionery composition in

which the migration of moisture is minimised further, or eliminated altogether, remains desirable.

Furthermore, moisture migration from the liquid core into the solid coating can be a particular problem in chewing gum or other confectionery compositions which  
5 comprise a low viscosity liquid filling. Low viscosity liquid fillings can be desirable for certain confectionery products because release of a low viscosity liquid during consumption provides a unique taste sensation. However, the prior art compositions referred to above all seek to increase the viscosity of the liquid fill in order to retard moisture migration. Alternative gum/confectionery compositions which are capable of  
10 accommodating any liquid filling, including low viscosity liquids, are desirable.

Conventional processes known in the art for forming centre-filled gum and other confectionery are relatively complex, typically involving the steps of forming the gum or other confectionery coating and then introducing a liquid fill into the centre of the gum or other confectionery by a suitable means. One example of such a process is  
15 described in International Patent Publication Number WO 02/15708 and consists of the extrusion of a so-called "rope" of liquid-filled chewing gum from a continuous extruder. This rope of liquid-filled gum is formed into individual pellets by a die assembly, which effectively crimps off individual pieces of gum from the rope. While this and other such processes are effective in continuously forming individual pieces of liquid filled gum,  
20 they tend to be complex procedures and require specialised equipment. Furthermore, the size of the gum pieces formed is typically large (generally of the order of 1 to 2 centimetres in length) and problems arise in adapting these processes to produce smaller pieces (e.g. 1.5 grams in weight or less) of liquid-filled gum or other confectionery compositions, which are desirable for certain applications.

The problems referred to above are addressed by the present invention.

According to a first aspect of the present invention there is provided a liquid-filled confectionery composition comprising:

- a) a core, wherein said core contains a liquid;
- 5       b) an outer coating or shell which encapsulates said core; and
- c) an intermediate layer disposed between said core and said outer coating;

wherein said core comprises a liquid encapsulated within a water soluble or biodegradable matrix layer and said intermediate layer is adapted to minimise liquid migration out of said core.

- 10       Such confectionery compositions address the problems associated with the prior art compositions identified above. Specifically, the provision of a liquid-containing core in which the liquid is encapsulated within a water-soluble matrix provides a convenient means by which any suitable liquid fill, including low viscosity liquids, can be incorporated into, and contained within, a confectionery composition. Furthermore,
- 15       the provision of an intermediate layer which is disposed between the outer coating and the liquid containing core provides a protective barrier which minimises moisture migration out of the core. The barrier provided by the intermediate layer may prevent moisture migration out of the core. Thus, in the final product, the barrier minimises or prevents moisture migrating from the liquid-containing core into the outer coating.
- 20       Hence, the intermediate layer minimises moisture migration and increases the stability of the composition.

Further, advantageously, this barrier may protect the integrity of the liquid-containing core from moisture present during the application of the outer coating layer

or layers, by minimising or even preventing moisture migration into the liquid-containing core.

Furthermore, suitable liquid-containing cores are commercially available. Thus, the intermediate layer and outer layer can be conveniently coated directly onto these  
5 commercially available cores using conventional coating techniques. Hence, the drawbacks associated with the techniques for the forming conventional liquid-filled gum or other confectionery compositions can be avoided.

For the avoidance of doubt, the term "core" is used herein to specify the innermost part of the composition. The core may take any suitable shape. The final  
10 product formed from the composition may also be of any shape.

The liquid present in the liquid-containing core may be any suitable liquid composition suitable for use in a confectionery composition. In particular, the liquid composition may comprise one or more flavouring agents, which may be natural or synthetic flavouring agents. Illustrative examples of suitable flavouring agents include  
15 peppermint and spearmint oils and essences; citrus oils including lemon, orange, lime and grape fruit; fruit essences including apple, peach, pear, apricot, grape, cherry, plum, pineapple and strawberry; and mixtures thereof.

Other ingredients such as sweeteners, softeners and buffering agents may also be present in the liquid. Suitable buffering agents are well known to those skilled in the  
20 art, as are suitable sweeteners and softeners. Illustrative examples of suitable sweeteners and the typical ranges in such constituents may be present are described at page 4, line 8, to page 6, line 11, of International Patent Publication No. WO 96/11582 (the contents of which are incorporated herein by reference). Illustrative examples of suitable softeners that may be present in the compositions of the invention are also

provided at page 6, lines 14 to 24, of International Patent Publication No. WO 96/11582 (the contents of which are incorporated herein by reference).

In certain embodiments, the liquid comprises one or more essential flavour oils.

The water soluble or biodegradable matrix, which encapsulates the liquid to  
5 form the liquid-containing core of the composition, may be formed from any suitable water soluble and/or biodegradable matrix-forming material. The matrix may be formed by one or more water soluble hydrocolloids. Illustrative examples of suitable hydrocolloids include gelatin, sodium alginate and mixtures thereof.

Suitable liquid-containing cores are commercially available from major flavour  
10 house companies, such as, for example, MANE Fils SA of 620 route de Grasse, 06620 Le bar Sur Loup, France or SYMRISE. These commercially available liquid-containing cores are typically spherical capsules containing one or more flavouring agents, typically essential oils, encapsulated within a gelatin (or another suitable hydrocolloid) matrix. These commercially available liquid-containing cores are generally known in the art as  
15 "capsules of flavours" and are obtainable in a range of different sizes and flavours. The size of the pearls of flavours selected for use in the compositions of the present invention will depend on the application concerned and the final size of the confectionery composition required. In certain embodiments of the invention, the pearls of flavour have diameters of between 3 and 10 millimetres and thereby enable small  
20 pieces of confectionery to be produced (i.e. confectionery pieces of 1.5 grams or less in weight).

The intermediate layer of the confectionery composition may be any suitable edible layer which, once formed, can minimise moisture migration out of the liquid-containing core. The intermediate layer may be a water impermeable layer, operative to

prevent moisture migration into and out of the liquid-containing core. As previously indicated, the intermediate protective layer may perform an important function by minimising moisture contacting the liquid-containing core during the remainder of the manufacture process (i.e. during the subsequent application of a confectionery coating) and thereby adversely affecting the water soluble matrix of the core. It also minimises moisture migrating from the liquid core into the outer confectionery coating during storage. The intermediate layer may be formed by coating the liquid-containing core with a coating solution which does not disturb the integrity of the water soluble or biodegradable matrix of the liquid-containing core. For example, if the matrix is a water soluble matrix, then the intermediate layer may be applied in any suitable non-aqueous solution, such as, for example, an alcohol-based solution.

The intermediate layer may comprise arabic gum. The intermediate layer may comprise maltodextrines or any other suitable binding ingredients. It may also comprise other constituents, such as, for example, a sugar alcohol (e.g. maltitol). The amount of arabic gum present in the intermediate layer may be 100% of the layer.

The intermediate layer may be applied to the liquid-containing core as an alcoholic solution and then dried to yield the intermediate layer.

The intermediate layer may be coated directly onto the surface of the liquid-containing core.

Usually one layer of intermediate protective coating will suffice, although several layers may be present. Where several layers are present, each layer may have the same or a different composition.

The outer coating may comprise any suitable confectionery coating that is known in the art. For instance, an outer confectionery coating may be in the form of a hard



confectionery shell, or it may be in the form of a chewable composition, such as chewing gum coating or any other soft chewable candy composition. The selection of an appropriate outer coating will depend on the type of confectionery product desired and can be easily carried out by a person skilled in the art.

5           The confectionery compositions of the present invention may be chewing gum compositions in which the outer confectionery coating is a chewing gum coating.

          The chewing gum coating may comprise any gum base constituents known in the art. Illustrative examples of suitable polymers that can be used as constituents of the gum base can be found at page 7, lines 10 to 24, of International Patent Publication No.  
10 WO 96/11582 (the contents of which are incorporated herein by reference). In embodiments of the invention in which the liquid-containing core is a commercially available pearl of flavour (as discussed above), the gum base typically contains at least one of the following gum base constituents: low and/or high molecular weight polyvinyl acetate; glycerol monostereate; vegetable oils (such as hydrogenated vegetable oil);  
15 microcrystalline petroleum wax or paraffin wax. The composition may comprise a mixture of some or all of the aforementioned constituents.

          The amounts of polymer utilised in the gum base will depend on the properties of the gum base desired. Typical amounts of polymer found in the gum base are disclosed at page 7, lines 25 to 34, of International Patent Publication No. WO 96/11582  
20 (the contents of which are incorporated herein by reference).

          The gum base may further comprise one or more additional agents such as, for example, sweeteners, elastomer solvents, emulsifiers, plasticizers, softeners, fillers, colouring agents, flavouring agents, antioxidants, and mixtures thereof. Illustrative examples of such agents and the typical ranges in which they may be employed can be

found at page 8, line 1, to page 11, line 13 of International Patent Publication No. WO 96/11582 (the contents of which are incorporated herein by reference).

In embodiments of the invention where the liquid-containing core is a commercially available capsule of flavour, the gum base may comprise one or more  
5 intense sweetening agents that provide a long lasting sweetening effect. Examples of such sweeteners include aspartame and acesulfam K.

In embodiments where the composition comprises a fruit flavour (in the liquid core and/or the outer chewing gum base), then flavour enhancers such as citric acid, for example, may also be incorporated into the gum base.

10 In some embodiments, the gum base may comprise various hydrocolloids, polyols and/or mixtures thereof.

The gum base may constitute anywhere between 5 and 90%, such as between 10 and 80%, of the entire confectionery/chewing gum composition. The actual percentage of gum base present will depend on the individual confectionery composition  
15 concerned.

The chewing gum coating may be further coated with an additional confectionery layer in order to provide a hard outer shell. Any suitable hard outer coating layer, such as a sugar or sugar alcohol-based coating, or a mixture thereof, may be used. Examples of suitable sugar alcohols that may be used to form the additional  
20 confectionery layer include sorbitol, xylitol, maltitol, isomalt and lactitol. The aforementioned sugar alcohols may be used alone or in admixture with one another.

The additional confectionery layer may optionally comprise any other suitable constituents, such as, for example, gelatin and arabic gum.

The compositions of the present invention may be of any shape or form that is desired.

According to a second aspect of the present invention there is provided a method of making a confectionery composition as defined herein, said method comprising the  
5 steps of:

- (1) providing a core, wherein said core contains a liquid;
- (2) coating said core with said intermediate layer; and
- (3) coating the product of the step (2) with an outer layer.

The compositions of the invention can be conveniently formed by the application  
10 of the intermediate, protective, layer coating to the liquid-containing core, followed by the application of the outer coating. Each coating step may be performed more than once, if so desired, to provide several individual layers of a given coating.

The coating process may be carried out as a batch process or a continuous coating process.

15 Any suitable coating technique may be used. For instance, the coating steps may be carried out by using conventional pan coating techniques. Once a coating solution has been applied, the coated compositions are then dried to yield the coated layer before the next coating step is commenced.

As previously indicated, the intermediate protective coating layer formed in step  
20 (2) above may be applied as a coating solution which does not disturb the integrity of the water soluble or biodegradable matrix of the liquid-containing core. Therefore, in embodiments where the matrix of the liquid core is a water soluble matrix, the use of an aqueous coating solution must be avoided.

In embodiments where the outer coating is a chewing gum coating, the method of making the compositions of the invention will further comprise an additional step in which the chewing gum coating is prepared for application in step (3) of the coating process defined above. The chewing gum coating may comprise granules of chewing gum base, which may be prepared by a granulation process. Said granulation process may comprise the following steps:

- (a) mixing the gum base ingredients to form the required gum base composition; and
- (b) cooling the gum base composition formed in step (a) and grinding the gum base into granules.

The mixing of the gum base ingredients may be carried out at any suitable temperature, although the temperature is typically below 70°C when the flavours are added to the gum base composition.

The gum base composition may be mixed by introducing the constituents into a kneader. This can be carried out as a continuous process or as a batch process.

Similarly, any suitable grinding process, such as the use of a knife grinder, may be used to reduce the gum base into granules.

Once formed, the granules of gum base may then be subjected to an additional screening step to select granules within a desired size range for use in the coating process. The screening is usually carried out by passing the granules through a mesh. Granules of less than 1000 microns in size may be used, such as granules of less than 500 microns.

The chewing gum coating is applied to the liquid-containing core which has been coated by the intermediate layer formed by step (2). The chewing gum base

granules may be dispersed into a suitable coating solution. Any suitable coating solution will suffice. The coating solution may comprise, in addition to the gum base granules, one or more hydrocolloids, such as arabic gum, and/or one or more polyols, or a mixture thereof. The coating step may be repeated several times until the required  
5 amount of gum coating has been deposited.

The process of producing the compositions of the invention may optionally include an additional step whereby any gaps between the individual granules of gum base forming the gum coating layer prepared in step (3) are filled by the application of a fine powder that disperses into said gaps and thereby increases the uniformity and  
10 continuity of the gum coating layer. Any suitable fine powder may be used for this purpose, such as, for example, a powdered polyol or icing sugar.

In embodiments of the invention in which the confectionery/chewing gum coating is further coated with a hard outer confectionery shell, the method of the present invention may further comprise an additional step in which the chewing gum coating  
15 formed in step (3) above is coated again to provide with said hard outer confectionery shell. Any suitable hard confectionery shell composition known in the art may be used in the compositions of the present invention. The outer shell may be formed from a sugar alcohol, such as maltitol, and may be applied by introducing a sugar alcohol syrup to coat the external surface of the outer confectionery/chewing gum layers of the  
20 composition produced in step (3). The sugar alcohol syrup is then dried to yield the hard outer confectionery shell.

The hard outer confectionery shell present in certain embodiments of the invention provides a smooth surface which can be cleaned and polished to provide an elegant finish to the compositions of the invention, if desired.

How an aspect of the present invention may be put into practice will now be described further in reference to the accompanying Fig. 1, which shows a diagrammatic illustration of a cross-section taken through an exemplary composition 10 of the present invention. In Fig. 1, a capsule of flavouring comprises flavours 11 encapsulated in a gelatin capsule 12. An Arabic gum intermediate protective layer 13 is applied, in alcohol, to the exterior of the gelatin capsule 12. This intermediate layer is sequentially coated with a gum base coating 14 and a hard coating 15.

A typical formulation of one embodiment of the composition 10 as depicted in Fig. 1 is set out below:

10

	<u>Component</u>	<u>% weight</u>	<u>Reference numeral in Fig. 1</u>
	Flavour	13.1	11
	Gelatin	1.7	12
	Arabic gum	0.8	13
15	Gum base	35.7	14
	Solution gum Arabic	14.0	14
	Maltitolp200	30.0	14
	Maltitol	4.7	15

20 The following further non-limiting Example is provided by way of illustration only.

**Example**

1. **Formation of the gum base**

A gum base having the following composition was mixed in a continuous kneader:

<u>Ingredients</u>	<u>% by weight of the gum base</u>
Polyvinyl acetate low molecular weight – grade 1.5	80.90
Aspartame	1.43
Acesulfame K	0.51
Hydrogenated vegetable oil	12.25
Glycerol monostearate	0.91
Liquid flavour (peppermint oil)	4.0

The gum composition was then ground into granules and sieved to yield granules  
5 of less than 500 microns.

2. Formation of the intermediate protective layer

To a commercially sourced liquid-containing core, namely capsules of flavours obtained from MANE Fils SA, 620 route de Grasse, 06620 Le bar Sur Loup France, an  
10 alcohol-based coating solution of maltitol P200 mixed with arabic gum (40/60) was added in a pan coater and agitated to form a continuous coating layer over the pearls of flavours. Only one layer (formed by a single application of the coating solution) was carried out.

15 3. Formation of the gum coating layer

The gum base granules prepared in step 1 above were mixed with a solution of arabic gum and applied in six successive applications to the product of step 2 above.

Maltitol powder is used to smooth the surface and fill any gaps between the gum base granules.

4. Formation of an outer hard confectionery shell

- 5 The outer shell is formed by the application of 15 coating layers of maltitol solution at 35°C.

The final product was then washed and polished.

The resultant chewing gum spheres contain 28% gum base per ball.



**CLAIMS**

1. A liquid-filled confectionery composition comprising:
  - (a) a core, wherein the core contains a liquid;
  - (b) an outer coating or shell which encapsulates said core; and
  - (c) an intermediate layer disposed between said core and said outer coating;wherein said core comprises a liquid encapsulated within a water soluble or biodegradable matrix layer and said intermediate layer minimises liquid migrating out of said core.
2. A composition according to claim 1, wherein said intermediate layer prevents liquid migrating out of said core.
3. A composition according to claim 1 or claim 2, wherein said intermediate layer also minimises liquid migrating into said core.
4. A composition according to claim 3, wherein said intermediate layer prevents liquid migrating into said core.
5. A composition according to any of the preceding claims, wherein the liquid present in the core comprises one or more natural or synthetic flavouring agents.
6. A composition according to any of the preceding claims, wherein the matrix layer of the core comprises one or more water soluble hydrocolloids.
7. A composition according to any of the preceding claims, wherein the core has a diameter of between 3 and 10 mm.
8. A composition according to any of the preceding claims, wherein the intermediate layer comprises arabic gum.
9. A composition according to claim 8, wherein the intermediate layer is entirely composed of arabic gum.

10. A composition according to any of the preceding claims, wherein the composition has a weight of 1.5 grams or less.
11. A composition according to any of the preceding claims, wherein said outer layer comprises chewing gum.
12. A composition according to claim 11, wherein the chewing gum comprises granules of chewing gum base.
13. A composition according to any of the preceding claims, wherein said outer layer is further coated with an additional layer in order to provide an outer shell of greater hardness than the said outer layer.
14. A composition according to claim 13, wherein the outer shell comprises at least one of sugar or sugar alcohol.
15. A composition according to claim 14, wherein the sugar alcohol is maltitol.
16. A composition according to any of the preceding claims, wherein said composition is manufactured by a method comprising the steps of:
  - (a) providing the core;
  - (b) coating said core with one or more intermediate layers; and
  - (c) coating the resulting product with one or more outer layers.
17. A method of manufacture of a liquid-filled confectionery composition as described in any of the preceding claims, said method comprising the steps of:
  - (a) providing a core, wherein said core contains a liquid;
  - (b) coating said core with one or more intermediate layers; and
  - (c) coating the resulting product with one or more outer layers.

18. A method according to claim 17, wherein the intermediate layer is formed by coating the core with a solution which does not disturb the integrity of the matrix of the core.

19. A method according to claim 18, wherein the matrix of the core is water soluble and the intermediate layer is applied in a non-aqueous solution.

20. A method according to any of claims 17 to 19, wherein the outer layer comprises granules of chewing gum base prepared by a granulation process, said granulation process comprising the steps of:

(a) mixing gum base ingredients to form the required gum base composition;

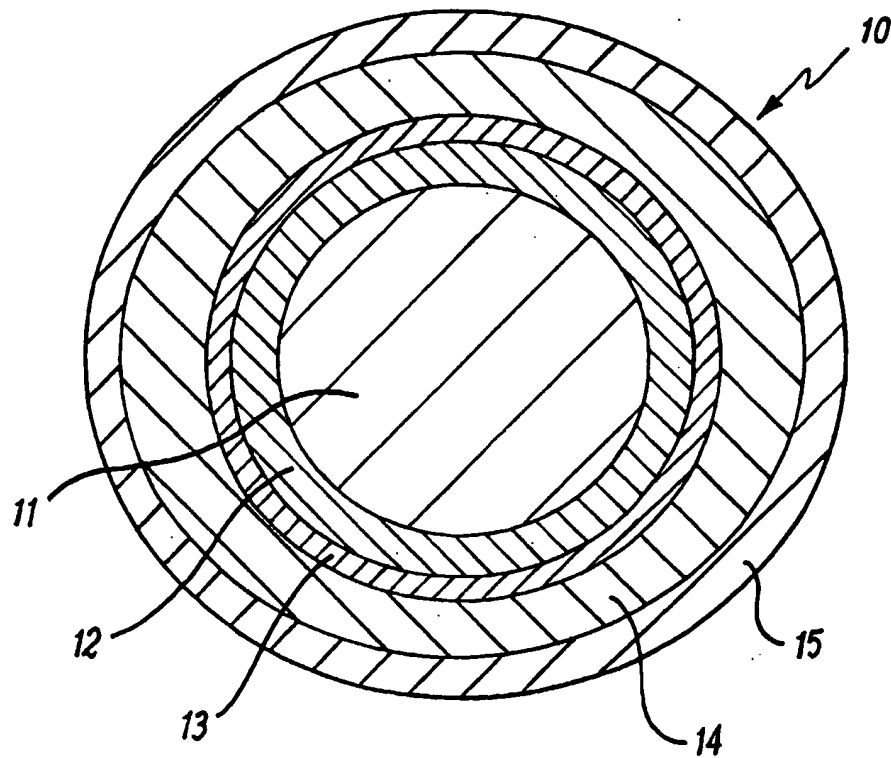
and

(b) cooling the gum base composition and grinding the gum base into granules.

21. A method according to claim 20, wherein the chewing gum granules are selected to be less than 1000  $\mu\text{m}$  in diameter.

22. A method according to claim 21, wherein the chewing gum granules are selected to be less than 500  $\mu\text{m}$  in diameter.

23. A method according to any of claims 17 to 22, wherein the outer layer comprises a chewable confectionery composition which is coated with a further layer to provide an outer shell, said shell being of greater hardness than said outer layer, said further layer being formed by coating the external surface of the chewable confectionery composition with at least one of a sugar or sugar alcohol syrup, followed by drying.

**FIG. 1**

## INTERNATIONAL SEARCH REPORT

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## A. CLASSIFICATION OF SUBJECT MATTER

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According to International Patent Classification (IPC) or to both national classification and IPC

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Minimum documentation searched (classification system followed by classification symbols)

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Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	FR 2 011 004 A (LEONARD MONHEIM FIRMA) 27 February 1970 (1970-02-27) page 2, line 25 - line 35; claims 1,7,8; example 1	1-5,13, 17
X	FR 2 285 078 A (GIEBELEN KARL) 16 April 1976 (1976-04-16) page 1, line 10 - line 18	1-5,17
X	EP 0 166 446 A (MIRABELL SALZBURGER CONFISERIE- UND BISQUIT GMBH) 2 January 1986 (1986-01-02) page 3, line 9 - page 4, line 7 page 6, line 28 - line 32; figure 1 ----- -/--	1-5

☒ Further documents are listed in the continuation of box C.☒ Patent family members are listed in annex.

## \* Special categories of cited documents:

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## INTERNATIONAL SEARCH REPORT

Inter-  
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C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT		
Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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